

Date: Friday, 19/12/2008 10:41:06 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 44202  
 Estimate Number : 11339  
 P.O. Number :  
 This Issue : 19/12/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : // Type : LARGE FAB ASSY  
 Previous Run : 37784  
 Drawing Name : PIN ASSEMBLY  
 Part Number : D3332041  
 Drawing Number : D3332 REV. A1  
 Project Number : N/A  
 Drawing Revision : A1  
 Material :  
 Due Date : 28/12/2008 Qty: 16 Um: Each  
 Written By :  
 Checked & Approved By : JULIE DAWSON  
 Comment : Est: A 05.01.13 New issue KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1018R0500 1018-1025 round bar .500



Comment: Qty: 0.3281 f(s)/Unit Total: 2.6250 f(s)

1018-1025 Steel Bar

Material: AISI 1018-1025 Ø0.500" Round Bar  
 (M1018-R0.500)

Identify for D3332-1

Batch: M106996

08/12/23

16 pcs

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine D3332-3 as per Folio FA493 and Dwg D3332

08/12/23

16 pcs

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/12/23

16 pcs

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/12/28

16

5.0 M1018R0313 1018-1025 round bar .313



Comment: Qty: 0.4594 f(s)/Unit Total: 2.6750 f(s)

1018-1025 Steel Bar

Material: AISI 1018-1025 Ø0.313" Round Bar  
 (M1018-R0.313)

Identify as D3332-5

Batch: M107436V

01-12

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 19/12/2008 10:41:06 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 44202

Part Number: D3332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Fabricate D3332-5 as per Dwg D3332

*PL 09.01.12*

(16)

7.0

D33321

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Handle Assembly

Pick:

Qty Part Number Description Batch

1 D3332-1 Handle

A/R N/A Steel Rod

Identify as D3332-041

*B44400 → 5✓*

*B37083 → 1\**

*B35935 → 10\**

*M105138*

*PL 09.01.13*

(16)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Assemble and Weld using D3332-041T1 as per Dwg D3332

*PL 09.01.13*

(X16)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 09.01.13*

(X16)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3  
Cover thread only for D3332-5 prior to painting

START TIME: *2130*

OVEN TEMPERATURE: *320°*

FINISH TIME: *3:00*

*FL 09/01/19*

(18)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*Am 09.10.20*

(16)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 19/12/2008 10:41:06 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 44202

Part Number: D3332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 483

96120

16

50

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/21/18

Job Completion



U 01.01.20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

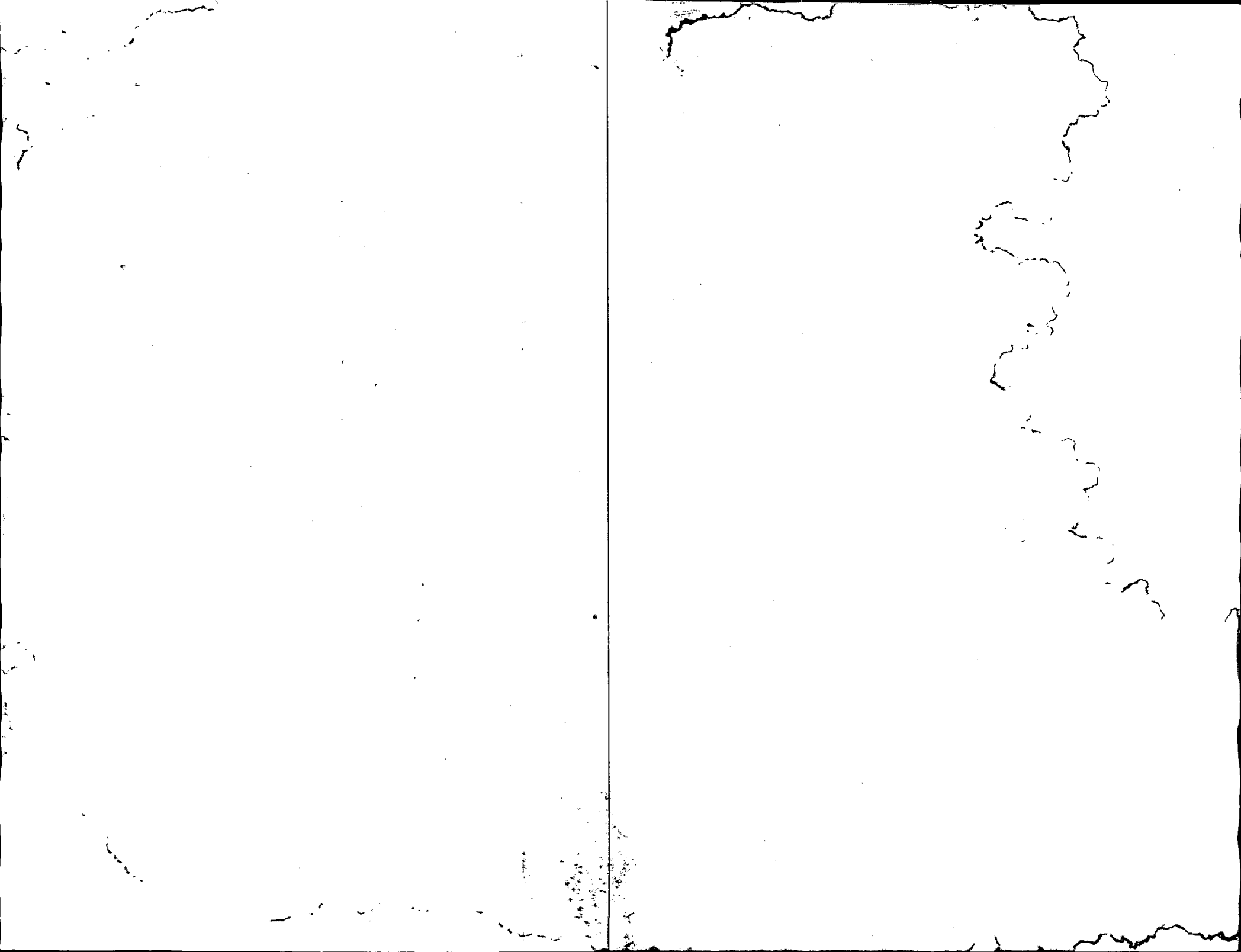
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

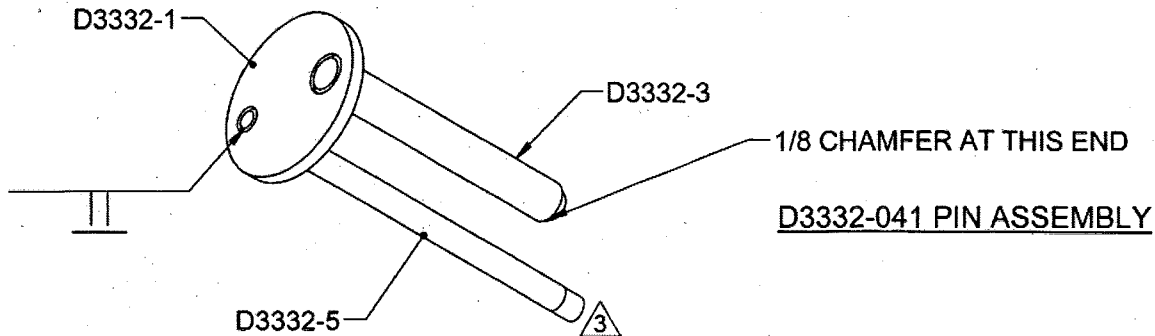




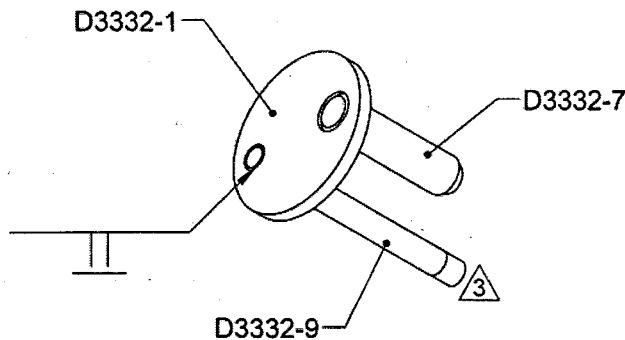


**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3332</b>	REV. A SHEET 1 OF 4
DATE <b>04.12.14</b>		TITLE <b>PIN ASSEMBLY</b>	SCALE 1:2
A	04.12.14	NEW ISSUE	
41	<i>[Signature]</i> 05.07.04	0.080 WAS 0.050; ADD TOLERANCE TO 0.001 -0.005	

**D3332-041 PIN ASSEMBLY**

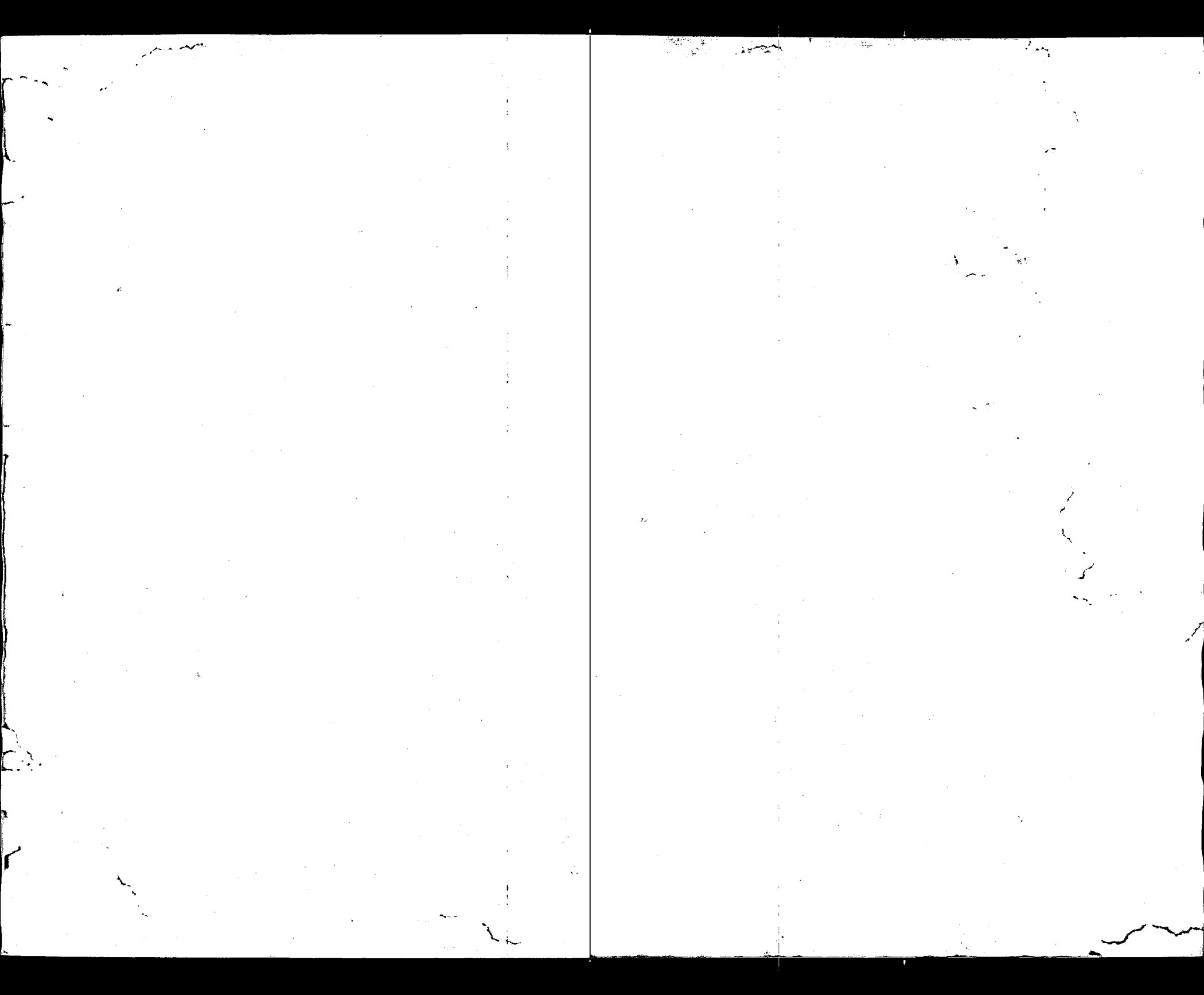
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*[Signature]*  
05/02/09

**D3332-043 PIN ASSEMBLY****NOTES:**

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3  
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

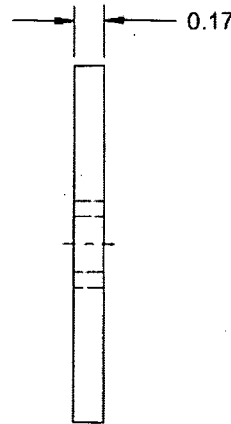
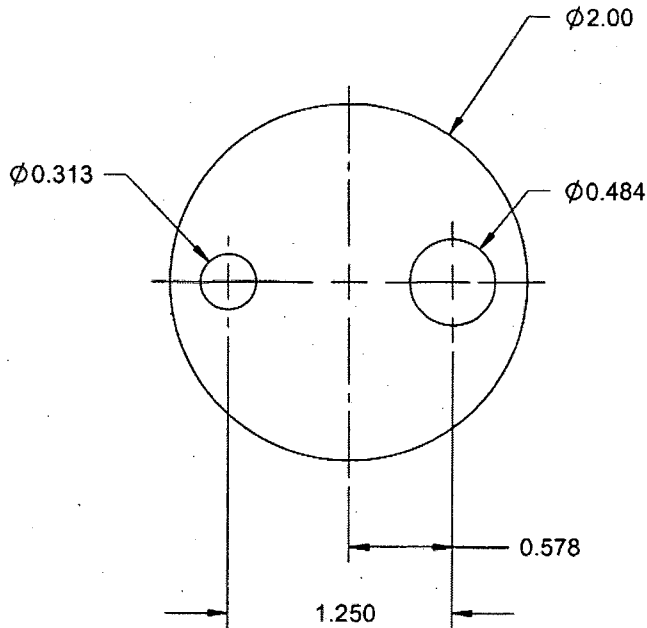
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1

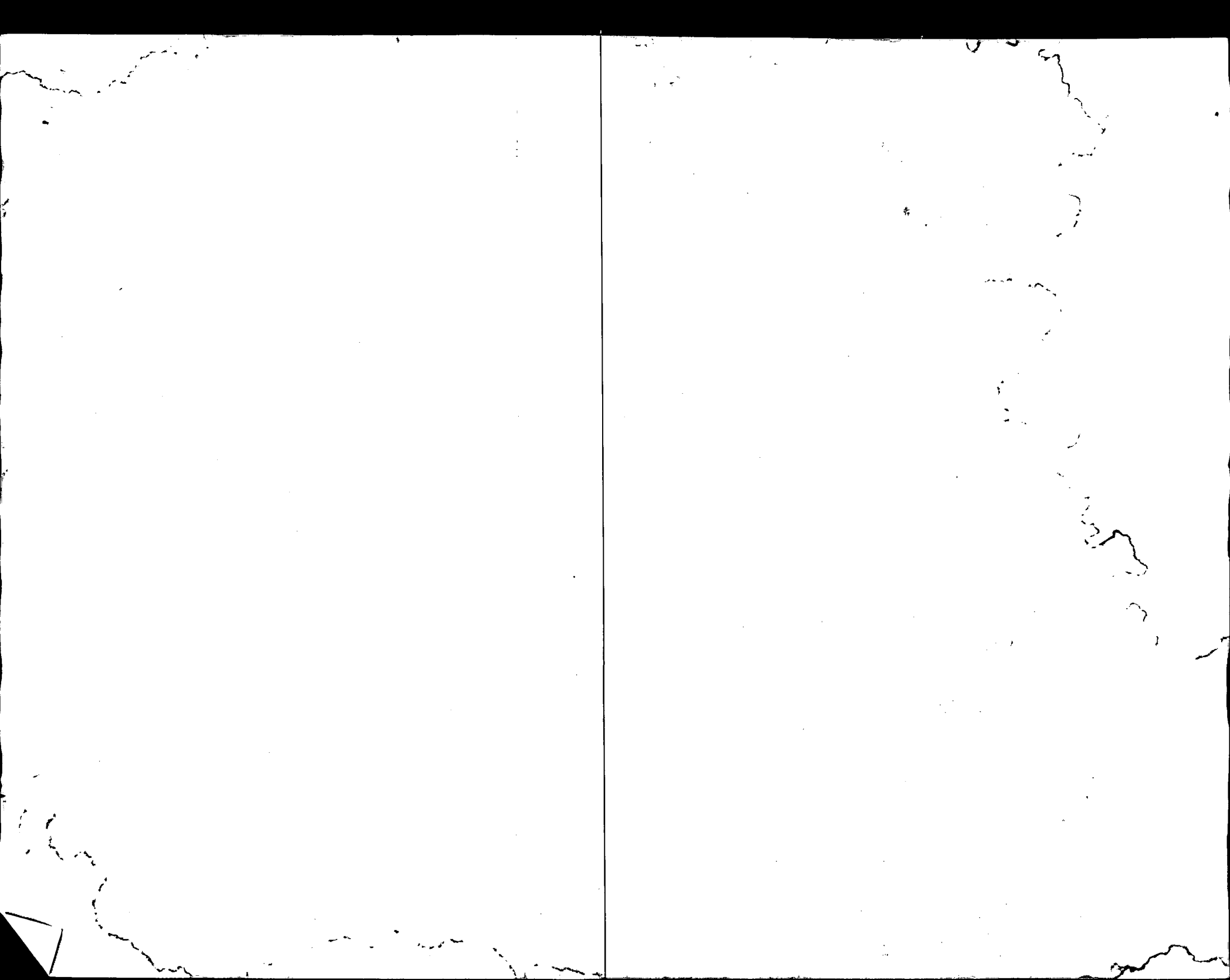
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*[Signature]*  
05/02/09**D3332-1 HANDLE****NOTES:**

- 1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097  
(REF. DART SPEC. M1018-R2.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

*[Signature]*  
14/202

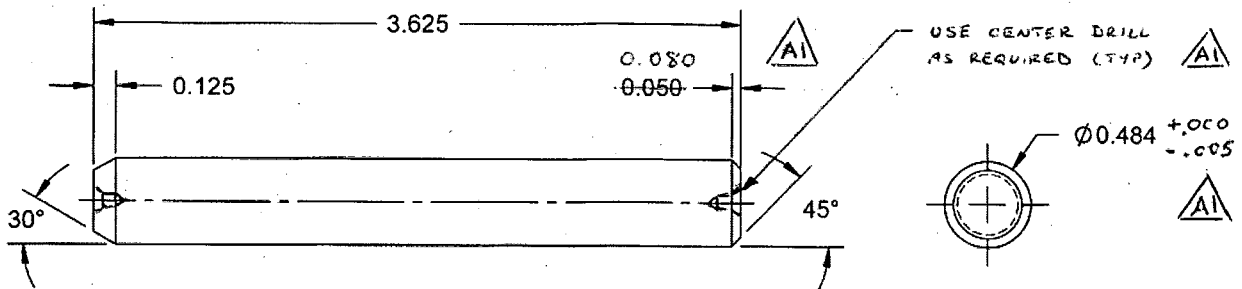
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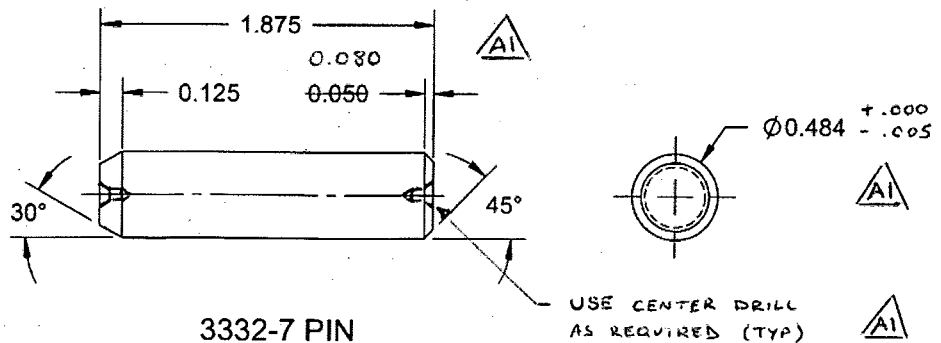
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



3332-3 PIN

RELEASED  
*[Signature]*  
05/02/09



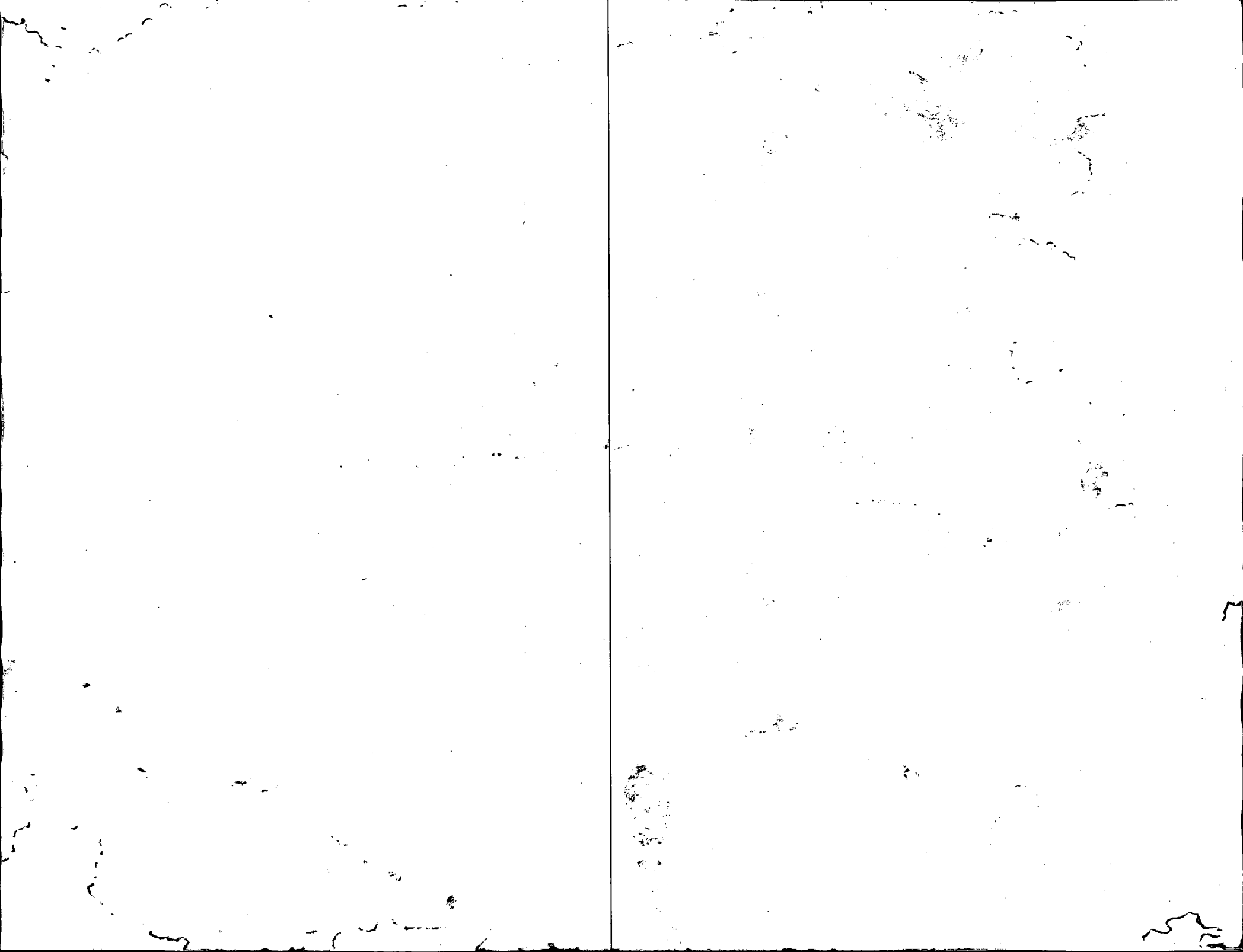
3332-7 PIN

**NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

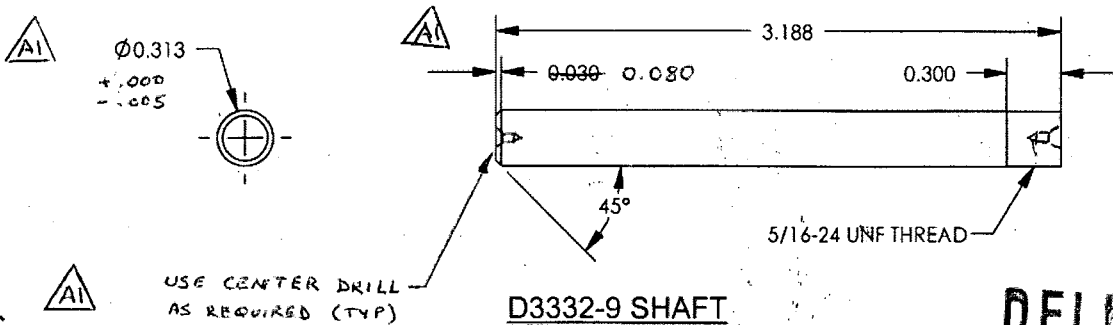
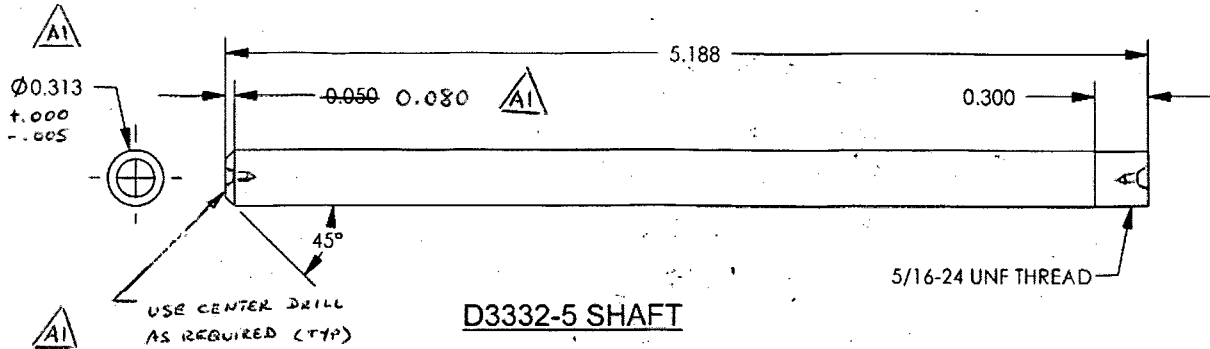
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DATE 04.12.14		TITLE PIN ASSEMBLY SCALE 1:1	



RELEASED  
6/20/09

**NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

SHOOT COPY  
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